

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019184**Date Inspected:** 06-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG Segment 12BE to 12CE for bottom splice joint weld No.OBE12C-001.

The welder is identified as #040458. ZPMC QC is identified as Mr.Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2231(T)-ESAB.

During random visual inspection at trial assembly area , before root pass welding of bottom splice joint OBE12C-001, this QA inspector verified the root opening of this joint and found accepted according to the approved WPS.

SMAW in the 4G position for the OBG Segment 12AE for UT repair joint weld No.SEG3001A-004. The welder is identified as #044515. ZPMC QC is identified as Mr.Wang Li Yang . The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair report is identified as CWR2703.

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SMAW in the 4G position for the OBG Segment 12BE for UT repair joint weld No.SEG3002A-001. The welder is identified as #050289. ZPMC QC is identified as Mr.Wang Li Yang . The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair report is identified as CWR2704.

SMAW in the 4G position for the OBG Segment 12AW for UT repair joint weld No.CA3007-005. The welder is identified as #040656. ZPMC QC is identified as Mr.Zhou Peng . The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair report is identified as WR18910.

SMAW in the 4G position for the OBG Segment 12AW to 12BW for UT repair joint weld No.OBW12D-002. The welder is identified as #046709. ZPMC QC is identified as Mr.Zhou Peng . The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair report is identified as CWR2709.

SMAW in the 4G position for the OBG Segment 12AW to 12BW for UT repair joint weld No.OBW12D-001. The welder is identified as #046709. ZPMC QC is identified as Mr.Zhou Peng . The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair report is identified as CWR2707.

CWR verifications (CWR2711 R0)

Type – (D-scan)

This QA Inspector was notified via email for verification of B – CWR2711 R0 at 1450 hours the following was observed:

- The component for verification Were identified as CA3012-009,OBW12-001 and OBW12-002 (12AW to 12BW deck panel field splice weld @ A1,A2 and A10)
- Weld repair was to be performed on location where rejectable indication was observed during Ultrasonic Testing (UT)
- ZPMC QC Zhou Zhog Hai was present on site to direct and record all repair work.
- WPS to be used for repair were WPS-345-SMAW-1G(1F)-FCM-Repair-1 and WPS-345-SMAW-4G(4F)-FCM-Repair-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

No relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Dsouza,Christopher	QA Reviewer

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